



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

646.9811

Job Sheet 205046



Part No: 646.9811

Job Qty: 2 pcs

Part Name: Upper Deflector



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 12/27/19

Job Tracking No:

Due Date: 2/14/20

Created By: Marie Lajeunesse

Type: ~~SOLD~~

Description:

Ship Via: *sfh*

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Bandsaw - 1	2 pcs	2/14/20	2/14/20	0.00	0.03	Bandsaw - 1	DAS 52 9-89	<i>B7 20-02-29</i>
110	HAAS 4 Axis - B4B	2 pcs	2/14/20	2/14/20	0.48	1.27	HAAS - 1 - B4B		<i>20-03-02</i>
							HAAS - 2 - B4B		
							HAAS - 3 - B4B		
							HAAS - 4 - B4B		
120	QC 2	2 pcs	2/14/20	2/14/20	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52	DAS 52 9-89	<i>10/03/02</i>
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S259648



Part: 646.9811

Job No: 205046

Serial No/Batch: S259648

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 03/02/20

				QC 2 - 66	
				QC 2 - 64	
				QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	
130 QC 8	2 pcs	2/14/20	0.00 0.00	QC 8 - 12	
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	
				QC 8 - 52	
				QC 8 - 23	
				QC 8 - 57	
				QC 8 - 76	
				QC 8 - 61	
140 Outsource - 4 - Anodize	2 pcs	2/14/20		ATG001-VC	15
150 Packaging 2-1 - Receive - B4B	2 pcs	2/14/20	0.00 0.00	Packaging 2 - 1 - B4B	
				Packaging 2 - 2 - B4B	
				Packaging 2 - 3 - B4B	
				Packaging 2 - 5 - B4B	
				Packaging 2 - 4 - B4B	
				Packaging 2 - 6 - B4B	
				Packaging 2 - 7 - B4B	
				Packaging 2 - 8 - B4B	
				Packaging 2 - 9 - B4B	
				Packaging 2 - 10 - B4B	
				Packaging 2 - 11 - B4B	
				Packaging 2 - 12 - B4B	
				Packaging 2 - 13 - B4B	
				Packaging 2 - 14 - B4B	
				Packaging 2 - 15 - B4B	
				Packaging 2 - 16 - B4B	
				Packaging 2 - 17 - B4B	
				Packaging 2 - 18 - B4B	
				Packaging 2 - 19 - B4B	
				Packaging 2 - 20 - B4B	
				Packaging 2 - 21 - B4B	
				Packaging 2 - 22 - B4B	
				Packaging 2 - 23 - B4B	
				Packaging 2 - 24 - B4B	

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					Packaging 2 - 25 - B4B	
					Packaging 2 - 26 - B4B	
					Packaging 2 - 27 - B4B	
					Packaging 2 - 28 - B4B	
					Packaging 2 - 29 - B4B	
					Packaging 2 - 30 - B4B	
					Packaging 2 - 31 - B4B	
					Packaging 2 - 32 - B4B	
					Packaging 2 - 33 - B4B	
					Packaging 2 - 34 - B4B	
					Packaging 2 - 35 - B4B	
					Packaging 2 - 36 - B4B	
					Packaging 2 - 37 - B4B	
155 QC 6	2 pcs	2/14/20	0.00 0.00		QC 6 - 9	
					QC 6 - 68	DAS
					QC 6 - 61	82
					QC 6 - 40	9-89
					QC 6 - 81	MAR 17 2020
180 Packaging 3-1 - Stock - B4B	2 pcs	2/14/20	0.00 0.00		Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	DAS
					Packaging 3 - 22 - B4B	41 MAR 17 2020
					Packaging 3 - 23 - B4B	9-89
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
					Packaging 3 - 37 - B4B	
190 QC 21 - SA	2 pcs	2/14/20	0.00 0.00		QC 21 - SA - 21	DAS
					QC 21 - SA - 70	21
					QC 21 - SA - 53	9-89 MAR 17 2020

Part Op 100 - (Bandsaw) Cut Blank at 32.700" *** ONE BLANK MAKES TWO PARTS***

- Descriptions: **110** - (HAAS CNC Vertical Machine) 1-Machine per folio FB131
120 - (QC2- Inspect parts off machine FAI/FAIB)
130 - (QC8- Inspect parts - second check)
140 - (Outsource process-Anodize per QSI017 4.1.10.1) Issue P/O to ATG : 46026 HARD ANODIZE COLOR BLACK, PRIME AS PER DWG 646.9800 REV. A
150 - (Receive & Inspect for Damage & Mat'l Certs)
155 - (QC6- All purchased or subcontracted products)
180 - (Identify as per dwg & Stock Location: ckell) ***IDENTIFY AS PER APICAL MPP-120 BY STAMPING P# AND REV***
190 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M7075T6S0.375X5.000	M7075T6S0.375 X 5.000	2.7200 ft (1.36 ea)	100-Bandsaw - 1	<u>5255553</u>

10-916'

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Bandsaw - 1	M7075T6S0.375X5.000	3	16	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Upper Deflector	0.130Inches ± 0.020	0.150 0.110	<u>0.130</u>	
2	Upper Deflector	45.0Angle ± 0.5	45.5 44.5	<u>45°</u>	
3	Upper Deflector	2.110Inches ± 0.002	2.112 2.108	<u>2.110</u>	
4	Upper Deflector	4.220Inches ± 0.002	4.222 4.218	<u>4.220</u>	
5	Upper Deflector	0.177Inches + 0.005 - 0.001	0.182 0.176	<u>0.177</u>	
6	Upper Deflector	0.375Inches ± 0.010	0.385 0.365	<u>0.375</u>	
7	Upper Deflector	0.700Inches ± 0.020	0.720 0.680	<u>0.700</u>	
8	Upper Deflector	0.340Inches + 0.000 - 0.005	0.340 0.335	<u>0.338</u>	
9	Upper Deflector	0.310Inches ± 0.010	0.320 0.300	<u>0.310</u>	
10	Upper Deflector	6.250Inches ± 0.020	6.270 6.230	<u>6.250</u>	
11	Upper Deflector	17.380Inches ± 0.020	17.400 17.360	<u>17.38</u>	
12	Upper Deflector	0.188Inches + 0.005 - 0.001	0.193 0.187	<u>0.188</u>	
13	Upper Deflector	49.8Angle ± 0.5	50.3 49.3	<u>49.8</u>	
14	Upper Deflector	41.3Angle ± 0.5	41.8 40.8	<u>41.3</u>	

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Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details: _____					



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

POHB046026



Supplier: ATG001-VC
A.T.G. Industries Inc
760 INDUSTRIELLE STREET
ROCKLAND
ON
K4K 1T2 Canada
Phone: 613-446-4544
Fax: 613-446-4556

Attention: Lalande, Marc-Andre

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: POHB046026

PO Date: 3/5/20

Due Date: 3/20/20

**Purchase Order
Revision:**

Revision Date:

Issued By: Guerin, Kimberley
Phone: 613-632-5200 Ext: 298
kguerin@dartaero.com

Via: Ground

Pymt Terms: Net 60

Freight Terms:

Special Comments:

E-MAILED
2020-03-11

Items

Line Item	Job	Part	Drawing	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	05058	647.1714	647.1700 Rev A	Plate : Various STC's (Outsource process- Anodize per QSI017 4.1.10.1) Issue P/O to ATG : Hard Anodize and Prime as Per Dwg 647.1700 Rev. E	Firmed	-	3/18/20	49 pcs	0 pcs	49 pcs	\$31.15/pcs	\$1,526.35
2	05059	647.1715	647.1700 Rev E	Plate : Various STC's (Outsource process- Anodize per QSI017 4.1.10.1) Issue P/O to ATG : Hard Black Anodize and Prime as per Dwg 647.1700 Rev. E	Firmed	-	3/18/20	30 pcs	0 pcs	30 pcs	\$31.15/pcs	\$934.50

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Tel (613) 632-5200

PURCHASE ORDER **POHB046026**



Items

Line Item	Job	Part	Drawing	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
3	205046	646.9811	646.9800 Rev A	Upper Deflector : Various STC's (Outsource process- Anodize per QSI017 4.1.10.1) Issue P/O to ATG : HARD ANODIZE COLOR BLACK, PRIME AS PER DWG 646.9800 REV. A	Firmed XB	-	3/20/20	8 pcs	0 pcs	8 pcs	\$33.50/pcs	\$268.00
											MAR 16 2020	
4	204004	C45-9-1	C45-9-1 Rev 6	Clock Spring Cover -Issue P/O -ANODIZE COLOR BLACK, PER IAW MIL-A- 8625F TYPE 2 CLASS 2, Water sealant -Material type 6061T6 -Certificate of Conformity is required	Firmed XAC	-	3/20/20	20 pcs	0 pcs	20 pcs	\$5.59/pcs	\$111.80
											MAR 11 2020	
5	205071	647.7612	647.7600 Rev N/C	Breakaway Tip : Various STC's Issue P/O to ATG : Hard Anodize, Color Black and Prime as Per Dwg 647.7600	Firmed X8	-	3/20/20	8 pcs	0 pcs	8 pcs	\$11.60/pcs	\$92.80
											MAR 16 2020	



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PURCHASE ORDER

POHB046026



Items

Line Item	Job	Part	Drawing	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
6	207545	654.3910	654.3900 Rev N/C	Handle -Issue P/O; -ANODIZE COLOR RED, PER IAW MPP- 172 Section 2.2 -Material type; 6061T6 -Certificate of Conformity is required	Firmed X7	-	3/11/20	7 pcs	0 pcs	7 pcs	\$5.59/pcs	\$39.13
7	205050	647.1513	647.1500 Rev E	Upper Deflector Issue P/O to ATG : Hard Anodize Color Black / Prime as per Dwg 647.1500	Firmed X12	-	3/20/20	12 pcs	0 pcs	12 pcs	\$12.95/pcs	\$155.40
8	200924	8NR-43	8NR-43 Rev 6	Side Plate-Mrk (Outsource process- Anodize per QSI017 4.1.10.1) -Issue P/O -ANODIZE COLOR BLUE, PER IAW MIL- A-8625F TYPE 2 CLASS 2, Water sealant -Material type 7075T6 -Certificate of Conformity is required	Firmed	-	3/20/20	5 pcs	0 pcs	5 pcs	\$5.59/pcs	\$27.95
Grand Total:											\$3,155.93	

Kherrin



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K6A 1K7
Canada

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PURCHASE ORDER

POHB046026



Order Notes

Procurement Quality Clauses
A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

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A.T.G. Industries Inc.
760 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 919824

Date: 16-Mar-20

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

Kimberley Guerin
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via	
		ATG Delivery	
Quantity	Description		
	Please reference this document's Pack List number on all correspondences regarding this shipment. If you have any questions, please contact us.		
8 ea	Part: 646.9811 Upper deflector Hard Black Anodize per MIL-A-8625F, Type III, Class2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0001-.0002" (1 - 2 mils) per drawing. Batch/Lot#: 128522 Job: 27063 PO: POHB046026		Rev: A Expiry Date: 05/29/2021 Line: 3
8 ea	Part: 647.7612 Breakaway Tip Hard Black Anodize per MIL-A-8625F, Type III, Class2, .0005-.0045" (.5 - 4.5mils). Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0001-.0002" (1 - 2 mils) per drawing. Batch/Lot#: 128522 Job: 27065 PO: POHB046026		Rev: NC Expiry Date: 05/29/2021 Line: 5
12 ea	Part: 647.1513 Upper deflector Hard Black Anodize per MIL-A-8625F, Type III, Class2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0001-.0002" (1 - 2 mils) per drawing. Batch/Lot#: 128522 Job: 27067 PO: POHB046026		Rev: E Expiry Date: 05/29/2021 Line: 7

DAS
82
9-89

RECEIVED
MAR 16 2020
DART AEROSPACE LTD.

Made in Canada.

DAS
82
9-89

RECEIVED

MAR 16 2020

DART AEROSPACE LTD.

Made in Canada.



A.T.G. Industries Inc.
760 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 919824

Date: 16-Mar-20

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

Kimberley Guerin
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via	
		ATG Delivery	
Quantity	Description		
	CERTIFICATE OF CONFORMANCE A.T.G Industries Inc. certifies that all items in this shipment conform to the requirements. Date: <u>MAR 16 2020</u> Certified Signature: <u>[Signature]</u> Receiver Signature: _____ A.T.G Industries Inc. is AS9100 Registered and Nadcap Chemical Processing Accredited. Note: This Packing Slip may contain parts that have been PLATED. Items that are plated may be subject to natural tarnishing and it is suggested that they be inspected within 24 hours of receipt.	DAS 82 9-89	
Made in Canada.			

Guillaume Gamache-Beauchamp

From: Patrick Duval
Sent: 16 mars 2020 15:08
To: Guillaume Gamache-Beauchamp
Subject: FW: Guillaume QC6

FYI

Pat Duval

From: Patrick Duval
Sent: March 16, 2020 2:15 PM
To: Michelle GagnonDonovan <mgagnondonovan@dartaero.com>; 'Marie Lajeunesse (mlajeunesse@dartaero.com)' <mlajeunesse@dartaero.com>; Zoe Evans (zevans@dartaero.com) <zevans@dartaero.com>; 'Shannon Hadley (shadley@dartaero.com)' <shadley@dartaero.com>
Cc: Marcel Daviau <mdaviau@dartaero.com>; Jason Leroux <jleroux@dartaero.com>; Serge Carriere (scarriere@dartaero.com) <scarriere@dartaero.com>; Valerie Miller <vmiller@dartaero.com>
Subject: Guillaume QC6

All
I have received & reviewed the training from Guillaume Gamache-Beauchamp regarding his inspection levels for QC6 and he is competent to perform this inspection levels.

Zoe,
Please adjust his training recorded to show that he has completed his training. (Stamp 82)

Shannon,
Please add the appropriate work center

Pat Duval
QC Coordinator

DART AEROSPACE
T: 1-613-632-5200 ext.228
www.dartaero.com
pduval@dartaero.com

